



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7813
Job Sheet 181398



Part No: 647.7813

Job Qty: 50 ea

Part Name: Center Plate, Lower



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV A 14/01/07 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		mark 18/08/18
100	Bandsaw	50 pcs	9/10/18	9/10/18	0.00	32.38	Bandsaw1		11
110	CNC Vertical Machining	50 pcs	9/10/18	9/10/18	0.56	32.37	HAAS1-1		11
120	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		11
130	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		11
140	Outsource	50 pcs	9/10/18	9/10/18			ATG001-VC	5	SEP 18-09-04
150	Packaging	50 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		SEP 18-09-04
160	QC	50 pcs	9/10/18	9/10/18	0.00	0.00	QC5		SEP 18-09-04
180	Packaging	50 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		SEP 18-09-04
190	QC21-SA	50 Ea	9/10/18	9/10/18	0.00	0.00	QC21		SEP 18-09-04

Part Op 100 - Cut Blank at 3.375"

Descriptions: 110 - 1-Machine per folio FB236

140 - Issue P/O to ATG : 18040921

Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B0.750X4.000	7075-T6 Bar 0.750" X 4.000"	14.0500 ft (.281 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6B0.750X4.000	14	5	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Center Plate Lower	2.858inches $\pm$ 0.005	2.863 2.853		
2	Center Plate Lower	1.160inches $\pm$ 0.005	1.165 1.155		
3	Center Plate Lower	3.171inches $\pm$ 0.005	3.176 3.166		
4	Center Plate Lower	3.072inches $\pm$ 0.005	3.077		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :					

			3.067	
5	Center Plate Lower	0.375inches $\pm$ 0.002	0.377 0.373	
6	Center Plate Lower	0.125inches $\pm$ 0.005	0.130 0.120	Radius
7	Center Plate Lower	0.325inches $\pm$ 0.005	0.330 0.320	Radius
8	Center Plate Lower	96.500Degrees $\pm$ 0.500	97.000 96.000	Angle
9	Center Plate Lower	6.500Degrees $\pm$ 0.500	7.000 6.000	Angle
10	Center Plate Lower	0.177inches $\begin{matrix} + 0.005 \\ - 0.001 \end{matrix}$	0.182 0.176	Diameter
11	Center Plate Lower	2.575inches $\pm$ 0.002	2.577 2.573	
12	Center Plate Lower	2.475inches $\pm$ 0.002	2.477 2.473	
13	Center Plate Lower	2.380inches $\pm$ 0.002	2.382 2.378	
14	Center Plate Lower	0.400inches $\pm$ 0.002	0.402 0.398	
15	Center Plate Lower	1.250inches $\pm$ 0.002	1.252 1.248	
16	Center Plate Lower	1.160inches $\pm$ 0.002	1.162 1.158	
17	Center Plate Lower	1.220inches $\pm$ 0.002	1.222 1.218	
18	Center Plate Lower	0.500inches $\pm$ 0.002	0.502 0.498	

Plex 7/26/18 8:11 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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 AEROSPACE
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 Serial No/Batch: S107255
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 08/31/18

1270 Aberdeen Street
 Hamilton, ON K6A 1K7
 CANADA
 TEL: 1 813 632-6200
 Email: sales@dartaero.com
 www.dartaerospace.com



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040921**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040921
PO Date: 9/4/18
Due Date: 9/26/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181398	647.7813	Center Plate, Lower Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg. 647.7800 Rev. A	Firmed	-	9/14/18	15 pcs	0 pcs	15 pcs	\$10.95/pcs	\$164.25
	182749			Firmed	-	9/26/18	35 pcs	0 pcs	35 pcs	\$10.95/pcs	\$383.25
Sub Total:							50	0	50		\$547.50

2	180124	646.3010	LH Half Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 646.3000	Firmed	-	9/14/18	12 pcs	0 pcs	12 pcs	\$12.45/pcs	\$149.40
3	178083	D4842-1	Lower Cutter Deflector Outsource process- Issue P/O to ATG : HARD ANODIZE COLOR BLACK, PRIME AS PER DWG D4842	Firmed	-	9/14/18	6 pcs	0 pcs	6 pcs	\$12.45/pcs	\$74.70
Grand Total:											\$771.60

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/5/18 11:25 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T7
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916043

Date: 17-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 50 ea	Part: 647.7813 ✓ Center Plate, Lower Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23673	Rev: A	PO: PO040921 ✓ Line: 1
✓ 12 ea	Part: 646.3010 ✓ LH Half Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23674	Rev: NC	PO: PO040921 ✓ Line: 2
✓ 6 ea	Part: D4842-1 ✓ Lower Cutter Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23675	Rev: B	PO: PO040921 ✓ Line: 3
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>17/09/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of Made in Canada.			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916043

Date: 17-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship to

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	receipt.		
Made in Canada.			